



# Work Order ID 56596

Tuesday, March 02, 2010 8:28:14 AM


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Item ID:	D3763-044	Accept		Setup	Start	
Revision ID:						
Item Name:	End Fitting Assembly, RH				Stop	
Start Date:	3/2/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	3/16/2010	Req'd Qty:	6.00		Customer:	
Reference:						


Approvals:	Process Plan:	<u>mf</u>	Date:	<u>10-3-2</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3763	Rev B								

100	Pick Kit	0.00								
	Packaging	Memo	0.00							
	Packaging									

Cpl 10.03.08

110	Large Fab	0.00								
	Large Fab	Memo	0.00							
	Large Fab	1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble and tack weld as per dwg D3763 using locating pin DT9039 *****look at dwg before assembling parts (RH) *****remove pin before welding***** 3-weld as per dwg D3763, QSI004 Alum								


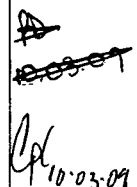
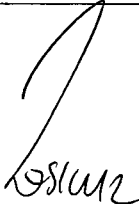
(6) Cpl 10.03.08

120	QC9- Inspect visual per QSI004- Fusion Welds	0.00								
	QC	Memo	0.00							
	Quality Control									

PD 10.03.09 Ph →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3763-044 PAR #: \_\_\_\_\_ Fault Category: Large Fish NCR: Yes No DQA: \_\_\_\_\_ Date: 10/03/16  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 10/03/16






NCR: <u>56596</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/3/16	120	welding inspection Found qty +1 Part with a crack. R.C. Process		Scrap + Destroy no Replace Qty +1	 10/03/16	S 10/03/16		S 10/03/16



NOTE: Date & initial all entries




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Start Date:	3/2/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	3/16/2010	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	S 10/03/09			(X5)	(40)		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00	H 10/03/10			(X5)	Ø		
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	BK 10-3-10			(5)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56596

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Item ID: D3763-044

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly, RH

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 251A

0.00



Packaging

Memo

0.00

Packaging

*Rec'd 3/60 (5)*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/03/11*  
*MF*  
*10-3-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, March 02, 2010 8:28:14 AM

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Work Order ID: 56596



Parent Item: D3763-044



Parent Item Name: End Fitting Assembly, RH

Start Date: 3/2/2010

Required Date: 3/16/2010

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec  
 IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC  
 IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3763-1		Manufactured	No			110	Each	13.0000	12.0000			
End Fitting												

*Cpl 10.03.08*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

54364

11

54433

2

D3763-6

Manufactured

No

110

Each

40.0000

6.0000

Tube



*Cpl 10.03.08*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40

42735

30

54798

10

✓ (11)  
(1)

✓ (10)  
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

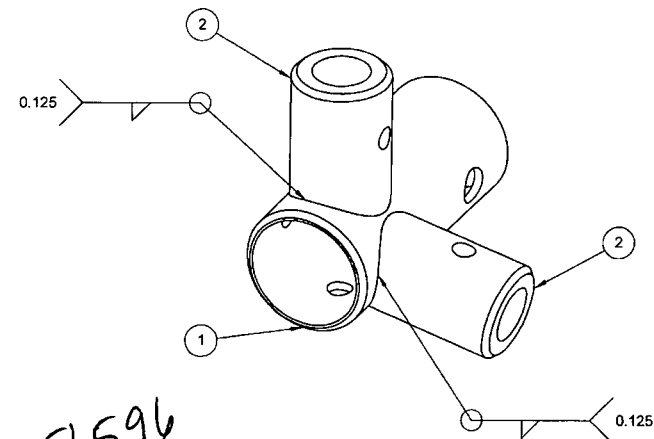
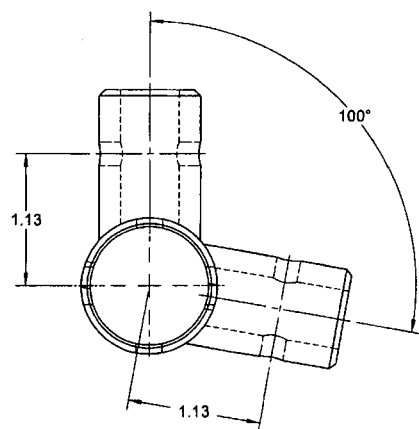
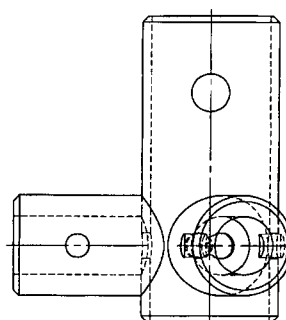
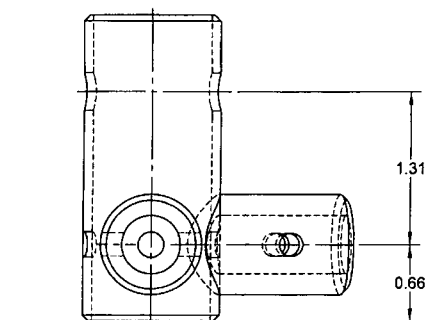
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





#56596

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

# **D3763-044 END FITTING ASSY, RH**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

RELEASED  
08-07-10

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. <b>D3763</b>	REV. B
MFG. APPR.	HS	SHEET 3 OF 9	
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	<b>END FITTING</b>	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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